

Date: Friday, 12/21/2007 7:27:53 AM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : AFT STRUT ASSEMBLY
Job Number : 36524	
Estimate Number : 11242	
P.O. Number :	Part Number : D3437043
This Issue : 12/21/2007 S.O. No. :	Drawing Number : D3437 REV B
Prsht Rev. : NC	Project Number : N/A
First Issue : / / Type : SMALL /MED FAB	Drawing Revision : B
Previous Run : 35872	Material :
Written By :	Due Date : 1/20/2008 Qty: 8 Um: Each
Checked & Approved By : <u>071221</u>	
Comment : Est. 05.05.20 New Issue KJ/JLM	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

1.0	D34371	Foot
-----	--------	------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 8.0000 Each(s)

Foot

Pick:

Qty	Part Number	Description	Batch
1	D3437-1	Foot	B36538

AS 08/01/15

(x8)

2.0	D34373	Clip
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 8.0000 Each(s)

Clip

Pick:

Qty	Part Number	Description	Batch
1	D3437-3	Clip	27065

AS 08/01/15

(x8)

3.0	D34379	Eye Bolt
-----	--------	----------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 8.0000 Each(s)

Eye Bolt

Pick:

Qty	Part Number	Description	Batch
1	D3437-9	Eye Bolt	35888 x2

* B36539 6x

AS 08/01/15

(x8)

4.0	AN960C516	WASHER
-----	-----------	--------



Comment: Qty.: 2.0000 Each(s)/Unit Total : 16.0000 Each(s)

Washer

Pick:

Qty	Part Number	Description	Batch
2	AN960C-516	Washer	M17697 x5 M102842 x11

AS 08/01/15

(x8)

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: D Date: 08/03/04
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Friday, 12/21/2007 7:27:54 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: AFT STRUT ASSEMBLY

Job Number: 36524

Part Number: D3437043

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

MS210435

Nut



Comment: Qty.: 1.0000 Each(s)/Unit Total : 8.0000 Each(s)

Self Locking Nut

Pick:

Qty Part Number

Description

Batch

1 MS21043-5

Self Locking Nut

M101418x3 M18535x5 AS 08/01/15 (x8)

6.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Assemble as per Dwg D3437 Dwg Rev: B

mf 08-03-03 (8)

7.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

08/03/03 (x5)

8.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 57155

08/3/3 (8)

9.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/03/04 (8)

Job Completion



mi 2008/3/04 (8)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

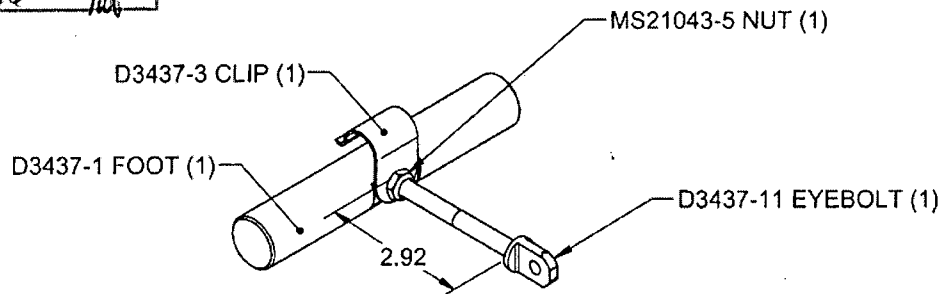
NOTE: Date & initial all entries



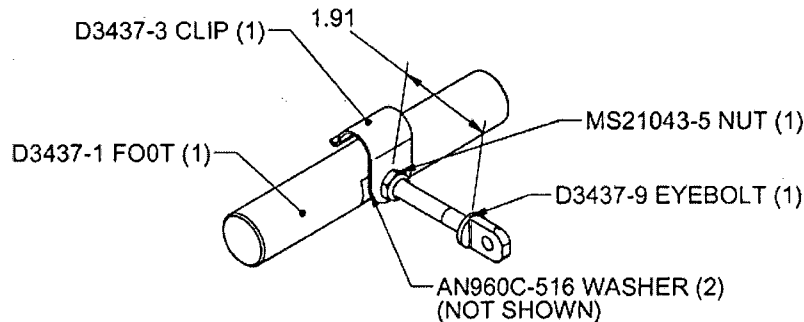
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CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3437	REV. B SHEET 1 OF 4
DATE 05.08.11		TITLE AFT STRUT ASSEMBLY	SCALE 1:2
A	05.04.29	NEW ISSUE	
B	05.08.11	UPDATE D3437-5/-9/-11 DIMENSIONS	

RELEASED

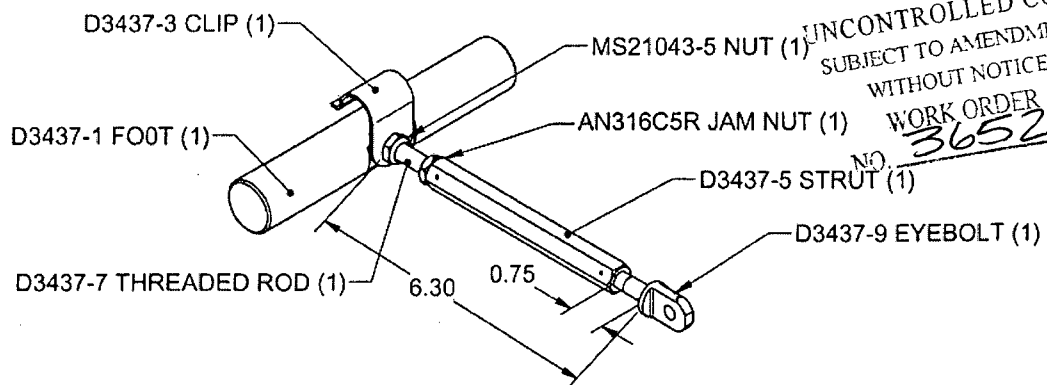
05.08.11 *[Signature]*



D3437-041 AFT STRUT ASSEMBLY



D3437-043 AFT STRUT ASSEMBLY



D3437-045 AFT STRUT ASSEMBLY

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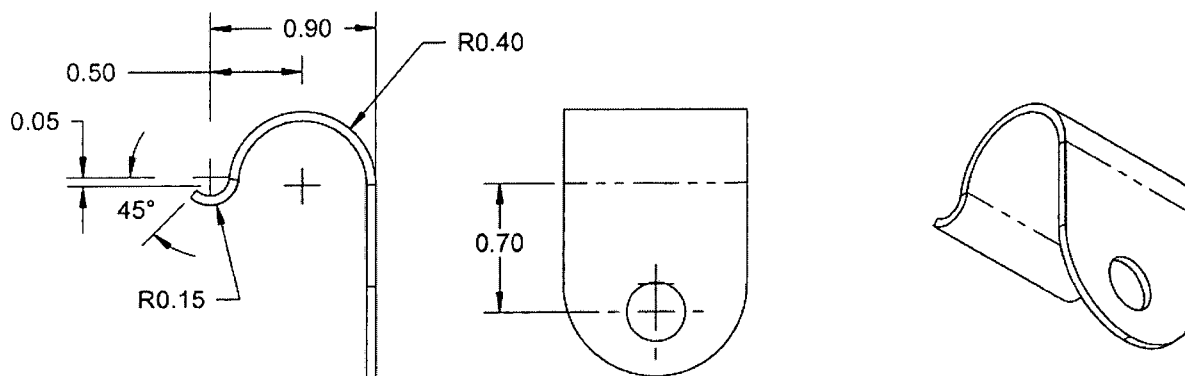
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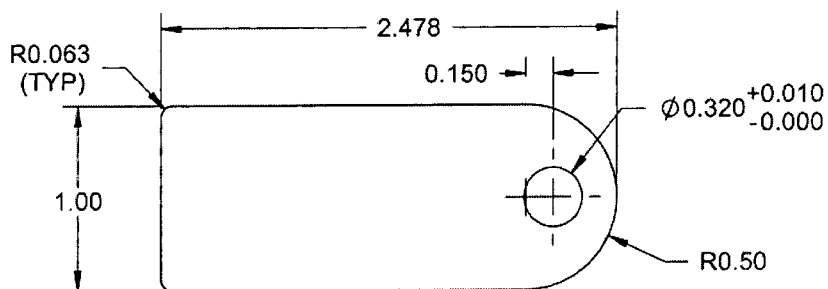
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DATE 05.08.11		TITLE AFT STRUT ASSEMBLY	SCALE 1:2

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05.08.16 *[Signature]*



D3437-3 CLIP
SCALE 1:1



D3437-3
FLAT PATTERN

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WITHOUT NOTICE
WORK ORDER
NO. 36524

D3437-3 CLIP:

- 1) MATERIAL: AISI 304/316 SS SHEET, 0.050 THICK (REF DART SPEC M304S18GA)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

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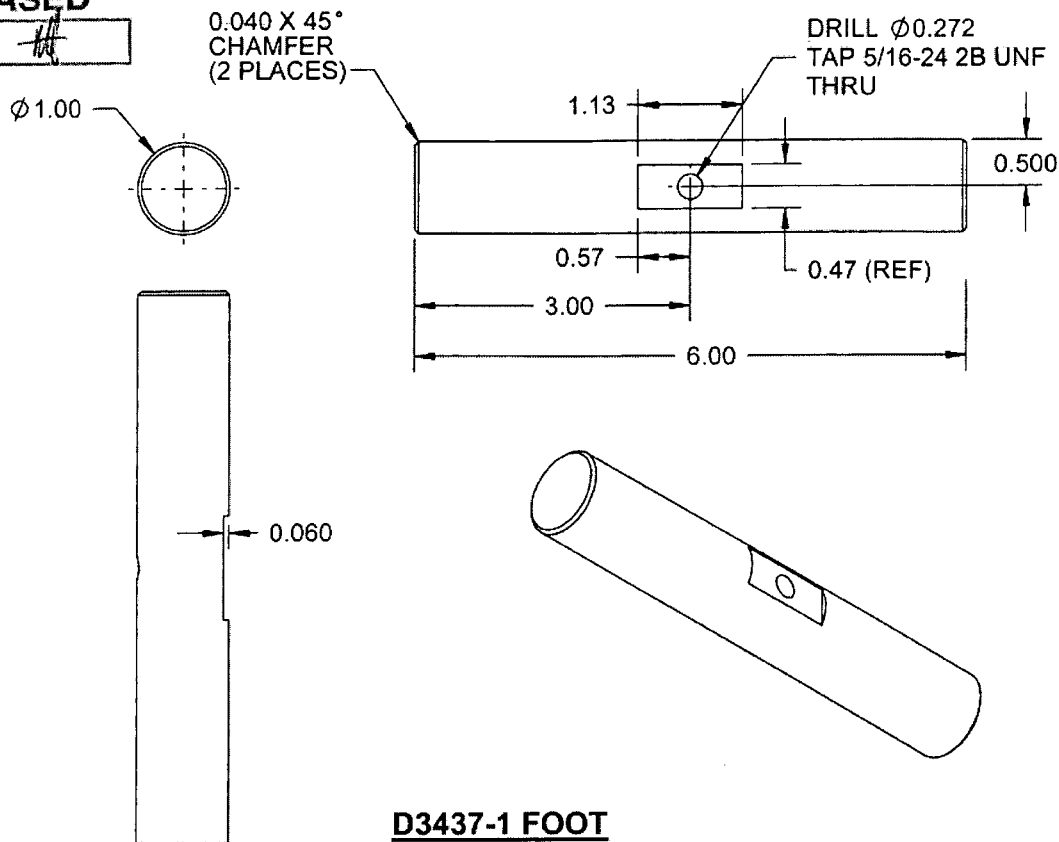
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DATE 05.08.11		TITLE AFT STRUT ASSEMBLY	SCALE 1:2

RELEASED

05-08-16 *[Signature]*

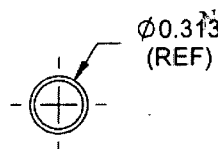
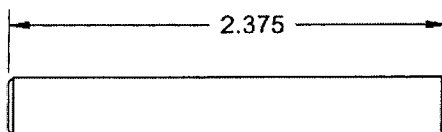


D3437-1 FOOT

D3437-1 FOOT:

- 1) MATERIAL: 6061-T6 (QQ-A-225/8 OR QQ-A-200/8) ALUMINUM ROUND BAR (REF. DART SPEC M6061T6R)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010

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D3437-7 THREADED ROD

D3437-7 THREADED ROD:

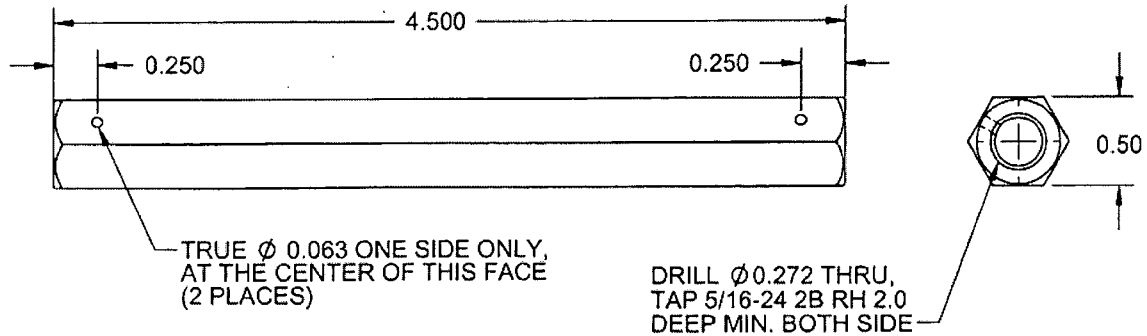
- 1) POSSIBLE SUPPLIER: HASKINS-SPAENAU P/N 870-832 18-8 5/16-24 SS THREADED ROD
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010

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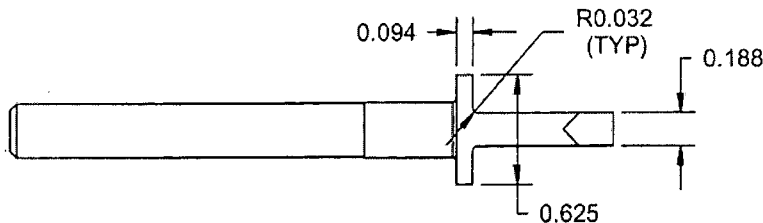


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DATE 05.08.11		TITLE AFT STRUT ASSEMBLY	SCALE 1:2



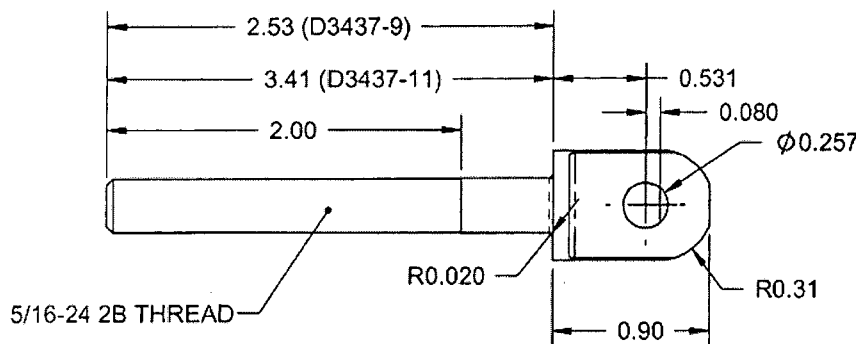
D3437-5 STRUT:

- 1) MATERIAL: AISI 303 STAINLESS HEX BAR (DART REF. SPEC M303H0.500)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010



RELEASED

05-08-16 [Signature]



D3437-9/-11 EYEBOLT:

- 1) MATERIAL: AISI 303 STAINLESS ROUND BAR (DART REF. SPEC M303R)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

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